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NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA

GB 31661-2025

**National food safety standard - Hygienic standards for the
production of prepared meat products**

食品安全国家标准 调制肉制品生产卫生规范

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National food safety standard - Hygienic standards for the production of prepared meat products

1 Scope

This standard specifies the basic requirements and management criteria for the sites, facilities, equipment and personnel involved in the procurement of raw and auxiliary materials, pretreatment, preparation and processing, cooling or freezing, packaging, storage and transportation during the production of prepared meat products.

This standard applies to the production of prepared meat products.

2 Terms and definitions

The terms and definitions defined in GB 14881, GB 2707 and GB 31646 and the following terms and definitions apply to this standard.

2.1 prepared meat products

Non-ready-to-eat meat products that are made from fresh (frozen) livestock and poultry products as the main raw materials, and are processed through pretreatment of raw and auxiliary materials, preparation and processing, cooling or freezing, and packaging, and need to be refrigerated or frozen for storage and transportation. They are also called processed meat products. They include refrigerated prepared meat products and frozen prepared meat products.

3 Site selection and factory environment

It shall comply with the relevant provisions of GB 14881.

4 Factory buildings and workshops

4.1 Design and layout

4.1.1 It shall comply with the relevant provisions of GB 14881.

4.1.2 The layout of workshops and equipment shall comply with the requirements of prepared meat products processing technology and be convenient for cleaning and disinfection.

4.1.3 According to the process requirements, pre-treatment workshops such as thawing room and dividing (cutting) room, preparation and processing workshops such as curing room, molding room, hot processing room, as well as cooling room, freezing room, inner packaging room, outer packaging room, raw material and auxiliary material storage warehouse, refrigerated product storage warehouse, frozen product storage warehouse, packaging material storage warehouse, etc. can be set up.

4.1.4 The pretreatment of raw and auxiliary materials shall be carried out in separate rooms or zones.

4.1.5 The inlet for raw materials and auxiliary materials shall be separated from the outlet for semi-finished products and finished products.

4.1.6 Raw material and auxiliary material storage warehouses or storage areas shall be set up separately according to the different types, odors and other characteristics of the raw materials and auxiliary materials.

4.1.7 Inner and outer packaging materials shall be stored separately in special warehouses or areas.

4.2 Building internal structure and materials

4.2.1 It shall comply with the relevant provisions of GB 14881.

4.2.2 The ceiling shall be easy to clean and disinfect, and its structure shall effectively prevent condensation from dripping vertically and prevent insect pests and mold growth.

4.2.3 The workshop shall have sufficient space and height to meet the needs of equipment installation and maintenance, production operations, sanitation and cleaning, material transfer, lighting and ventilation, and health inspection.

5 Facilities and equipment

5.1 General requirements

5.1.1 It shall comply with the relevant provisions of GB 14881 and GB 31646.

5.1.2 The structural design and placement of facilities and equipment shall facilitate cleaning and disinfection to avoid the retention and growth of pollutants containing harmful microorganisms.

5.1.3 Facilities and equipment shall be regularly inspected and repaired, and damaged parts shall be replaced in a timely manner to prevent metal debris, lubricating oil and other substances from contaminating the product.

5.2 Ventilation facilities and equipment

The hot processing room in which scalding, steaming, frying, smoking and other heating processes are carried out shall be equipped with good ventilation facilities and equipment.

5.3 Cleaning and disinfection facilities and equipment

5.3.1 Workshops with different cleanliness requirements shall be separately equipped with necessary cleaning and disinfection facilities and equipment.

5.3.2 Cleaning facilities and equipment for livestock and poultry products and other auxiliary materials shall be set up separately, and their configuration shall be adapted to the processing capacity. The purpose of each type of facilities and equipment shall be clearly marked.

5.4 Temperature and humidity monitoring equipment

Temperature, humidity and other control, display and recording devices shall be installed and configured according to environmental condition control requirements, and shall be calibrated and maintained regularly.

5.5 Water supply and drainage facilities and equipment

5.5.1 According to the production process requirements, cold and hot water pipes shall be installed separately at the water use location in the workshop. The cold and hot water pipes shall be clearly distinguished and marked with the flow direction.

5.5.2 The drainage outlet shall be equipped with water-sealed floor drains, filters and other devices to prevent foul air from escaping and solid waste from clogging the drainage pipe.

5.6 Waste storage facilities

The workshop shall be equipped with special facilities for storing waste that are leak-proof, corrosion-resistant and easy to clean, and have clear distinguishing signs.

6 Hygiene management

It shall comply with the relevant provisions of GB 14881.

7 Food raw materials, food additives and food-related products

7.1 General requirements

7.1.1 It shall comply with the relevant provisions of GB 14881.

7.1.2 A special system shall be established for the procurement, acceptance, storage and use of food raw and auxiliary materials, food additives and food-related products, and relevant records shall be kept.

7.2 Food raw materials

7.2.1 Raw materials of livestock and poultry products shall have quarantine certificates, and pork shall also have meat quality inspection certificates. Imported livestock and poultry products shall have relevant certification documents for entry goods.

7.2.2 Raw materials of fresh (frozen) livestock and poultry products shall comply with the requirements of GB 2707 and related standards.

7.3 Food auxiliary materials

7.3.1 Auxiliary materials such as starch, seasonings and spices shall comply with relevant standards.

7.3.2 The qualification certification documents of auxiliary materials shall be checked and they can only be used after they have passed acceptance inspection.

7.4 Food additives

7.4.1 Food additives shall comply with the requirements of the relevant national food safety standards and their use shall comply with the provisions of GB 2760.

7.4.2 When inspecting compound food additives, the specification sheet of the compound food additives' scope of use and maximum addition amount (or usage amount) shall be requested. The scope of use and limit of food additives in ingredients shall comply with the provisions of GB 2760.

7.4.3 A weighing and verification system shall be established for the use of food additives.

7.5 Food-related products

7.5.1 Packaging materials shall meet food safety requirements.

7.5.2 If the prepared meat products need to be packed with inner packaging to complete the heating process, the inner packaging shall be made of heat-resistant materials; if the prepared meat products need to be stored frozen, the inner packaging shall be made of low-temperature resistant materials.

7.5.3 The skewers used for skewering prepared meat products shall comply with the requirements of GB 4806.9, GB 4806.12, etc.

7.5.4 The smoking materials or smoking seasonings used for smoking shall comply

with the relevant standards.

8 Food safety control during the production process

8.1 General requirements

8.1.1 It shall comply with the relevant provisions of GB 14881.

8.1.2 Production water shall comply with the relevant provisions of GB 5749.

8.1.3 The temperature and processing time in the raw material and semi-finished product processing shall be controlled in accordance with the product processing technology requirements.

8.1.4 When raw materials and auxiliary materials are stored, if there are special requirements for storage temperature and humidity, effective measures shall be taken to monitor the temperature and humidity of the storage environment and records shall be kept. Fresh livestock and poultry raw materials shall be stored in a storage warehouse at 0 °C~4 °C, and frozen livestock and poultry products shall be stored in a storage warehouse below -18 °C.

8.1.5 The storage of raw and auxiliary materials shall follow the first-in-first-out principle.

8.2 Pretreatment of raw materials and auxiliary materials

8.2.1 Raw material pretreatment includes all or part of the processing procedures such as thawing, deboning, cutting, sorting, grinding, and dicing (shredding).

8.2.2 Appropriate thawing methods shall be selected based on the characteristics of frozen livestock and poultry products and processing technology requirements. The core temperature of livestock and poultry products after thawing shall not be higher than 4 °C.

8.2.3 When air is used for thawing, the ambient air shall be non-toxic, harmless, free of abnormal odor and comply with relevant standards. When static airflow is used for thawing, the ambient temperature shall not be higher than 18 °C; when flowing air is used for thawing, the ambient temperature shall not be higher than 21 °C.

8.2.4 When thawing with normal pressure water, the water temperature for static water thawing shall not be higher than 18 °C, and the water temperature for running water thawing shall not be higher than 21 °C. Raw materials of different livestock and poultry species shall not be thawed in the same water medium.

8.2.5 When deboning, cutting, sorting, dicing (shredding) or grinding livestock and

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